

What is claimed is:

1. A subassembly for a shaving razor comprising  
a plurality of elongated metal blades having cutting edges defining a shaving surface,  
said blades being secured to each other by first and second weld connections to provide an integral unit, said blades having first and second longitudinal ends,  
said first longitudinal ends being connected to each other by said first weld connections,  
said second longitudinal ends being connected to each other by said second weld connections,  
said blades being secured only at said first and second longitudinal ends.
2. The subassembly of claim 1 wherein said first and second longitudinal ends are bent and are transverse to said cutting edges.
3. The subassembly of claim 1 or 2 further comprising a first metal plate and a second metal plate, said first longitudinal ends being connected by said first weld connections to said first metal plate, said second longitudinal ends being connected by said second weld connections to said second metal plate.
4. The subassembly of claim 2 wherein each said first longitudinal end of one said blade overlaps and is welded to at least one other first longitudinal end of a different said blade, and wherein each said second longitudinal end of one said blade overlaps and is welded to at least one other second longitudinal end of a different said blade.
5. The subassembly of claim 1 wherein each said blade includes an elongated cutting member having said cutting edge and an elongated support to which said

- elongated cutting member is attached, each said elongated support having a said first longitudinal end and a said second longitudinal end.
6. The subassembly of claim 1 wherein each said blade includes an elongated cutting member portion having said cutting edge and an integral elongated support portion bent downward from said cutting member portion, each said elongated support portion having a said first longitudinal end and a said second longitudinal end.
  7. The subassembly of claim 1 wherein each said blade includes an elongated cutting member having said cutting edge and a said first longitudinal end and a said second longitudinal end.
  8. The subassembly of claim 3 wherein said first and second plates have a stainless steel base and an aluminum cladding thereover.
  9. The subassembly of claim 1 wherein said plurality of elongated metal blades includes at least two said blades.
  10. The subassembly of claim 1 wherein said plurality of elongated metal blades includes at least three said blades.
  11. The subassembly of claim 1 wherein said plurality of elongated metal blades includes at least four said blades.
  12. The subassembly of claim 1 wherein said plurality of elongated metal blades includes five or more said blades.
  13. The subassembly of claim 1 wherein all said cutting edges are in a common plane.

14. The subassembly of claim 1 wherein said subassembly has a snap-fitting structure for connection to a housing of a shaving razor.
15. A shaving razor comprising the subassembly of claim 1 and a housing having a recess in which said subassembly is secured.
16. A method of making a shaving razor comprising
  - providing a plurality of elongated metal razor blades having cutting edges and first and second longitudinal ends,
  - positioning said cutting edges parallel to each other and spaced from adjacent cutting edges so as to define a shaving surface,
  - connecting first longitudinal ends to each other by welding first weld connections during said positioning,
  - connecting said second longitudinal ends to each other by welding second weld connections during said positioning to result in an integrated blade unit.
17. The method of claim 16 wherein said positioning includes using a fixture to align said blades in parallel planes and to position said cutting edges at desired positions.
18. The method of claim 17 wherein said fixture has slots to align said blades and stop surfaces to position said cutting edges.
19. The method of claim 16 further comprising
  - providing a housing having a recess therein, and
  - positioning said integral unit in said recess.
20. The method of claim 19 wherein said recess is open to the top, and said positioning involves lowering said unit into said recess.

21. The method of claim 20, further comprising holding said unit in said housing by a pair of metal clips.
22. The method of claim 20, further comprising holding said unit in said housing by a snap-fit connection.
23. The method of claim 19 wherein said recess is open to the bottom, and said positioning involves raising said unit into said recess.